

Work Order ID 136831

September 09, 2015 3:39:46 PM

136831

Page 1

Item ID: D119-796-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step

Start Date: 9/9/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:  Date: 01509019 Poling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-796	E								
100 *100*	Document Control DOCUMENT CONTROL	0.00							DAS 02 9-89
DC Doc.Control USB or Paperwork	Memo Photocopy bluefile & type labels per PPP D119-796-201 CHG004	0.00							
110 *110*	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							DAS 27 9-89
									SEP 10 2015
120 *120*	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.03							DAS 02 9-89

SEP 28 2015

SEP 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 136831

September 09, 2015 3:39:46 PM

136831

Page 2

Item ID: D119-796-201

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: AFT Crosstube Installation with Step

Stop

NS2

Start Date: 9/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D119-796-201 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF 15-9-28

MCS SEP 28 2015

MF 15-9-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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136831

D1 19-796-201

Required Date: 9/23/2015

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM IPP
REV:B 14.10.22 AS PER PA1 DD VERF:JLM IPP REV:C
14.11.19 AS PER IIN REV.B DD VERF:JLM IPP REV D 15.02.13
AS PER REV C JLM VERIFIED BY:DD IPP REV:E 15.05.13 PER
REV D JLM VERIFIED BY:DD IPP REV:F 15.08.25 AS PER IIN
REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DP460		Purchased	No				Each	0.0000		1			DAS 9-89
DP460	DAS 02 9-89									1			DAS 27 9-89
Scotch Weld Adhesive													
MS21920-28		Purchased	No				Each	206.0000		2			DAS 27 9-89
MS21920-28									**				DAS 27 9-89
Clamp	DAS 02 9-89												DAS 27 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FG			1						
				105884			1						
				LG050			128						
				M130400			50						
				M130665			2						
				M133090			38						
				M133091			38						
				LG051			77						
				M132169			38						
				M132381			1						
				M132522			38						
D119-796-251		Manufactured	No				Each	1.0000		1			DAS 27 9-89
D119-796-251	DAS 02 9-89								**				DAS 27 9-89
AFT Crosstube Installation with Step (no hardware)													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FG			1						
				134490			1						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Picklist Print

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Page 2

Work Order ID: 136831

Parent Item: D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

136831

D119-796-201

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

Each

786.0000

8

D3672-7

Washer, Phenolic

DAS
02
9-89

**

DAS
27
9-89
SEP 10 2015

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST051A

500

134786

500

ST055

246

120476

6

129987

39

133986

201

8

AN5C32A

Purchased

No

Each

143.0000

4

AN5C32A

BOLT

DAS
02
9-89

**

DAS
27
9-89
SEP 10 2015

Location

Loc Qty

Loc Code

FG

4

18918

4

ST286A

100

131650

100

ST336

39

m132102

39

4

MS21250-05048

Purchased

No

Each

0.0000

MS21250-05048

BOLT (use MS21250-05-048)

DAS
02
9-89

**

133157

DAS
27
9-89

DAS
27
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 3

Work Order ID: 136831

136831

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

AN5C7A

Purchased

No

Each

323.0000

12

AN5C7A

BOLT

DAS
02
9-89

**

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

2

19185

2

ST286A

150

m131320

150

ST338

171

~~m132123~~

71

m132930

100

12

MS21043-5

Purchased

No

Each

272.0000

4

MS21043-5

Nut

DAS
02
9-89

**

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

76

116548

76

ST304

176

m129499

4

m132382

172

4

NAS1149C0532R

Purchased

No

Each

423.0000

8

NAS1149C0532R

WASHER

DAS
02
9-89

**

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST271

363

m128537

40

~~m131624~~

23

m133031

300

8

SEP 10 2015

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
☐ OTHER : _____											

Picklist Print

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Work Order ID: 136831

136831

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0563R

Purchased

No

Each

547.0000

12

NAS1149C0563R

DAS

02

9-89

Washer

DAS

27

9-89

DAS

6

9-89

SEP 10 2015

Location

Loc Qty

Loc Code

ST260a

500

m131697

500

ST271

47

m131026

47

~~M131026~~

12

DQA: _____ Date: _____

H:/FORMS/Quality Assurance

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DAS
02

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2	8	8	8	8					D3672-7	WASHER
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4		4	4	D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12							2		D5149-041	FWD STEP ASSY
13								2	D5149-043	AFT STEP ASSY
14					2				D5152-041	FWD POST MOUNT ASSY
15						2			D5152-043	AFT POST MOUNT ASSY
16						16			CR3212-4-07	RIVET
17					16				CR3212-4-08	RIVET
18							4		MS21920-22	CLAMP
19					4				MS21920-24	CLAMP
20						6		4	MS21920-25	CLAMP
21		2		2		2			MS21920-28	CLAMP
22	4	4	4	4					AN5C32A	BOLT
23	4	4	4	4					MS21250-05048	BOLT
24	12	12	12	12					AN5C7A	BOLT
25	4	4	4	4					MS21043-5	NUT
26	8	8	8	8					NAS1149C0532R	WASHER
27	12	12	12	12					NAS1149C0563R	WASHER
100		1		1					DP460	SCOTCH WELD ADHESIVE (37mL)

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Revision: E
Date: 15.07.06